

**Work Order ID 59147**

Thursday, May 27, 2010 9:20:29 AM



Page 1

Item ID: D3953-9

Accept



Setup Start



Revision ID:

Item Name: Gas Spring Washer

Stop



Start Date: 5/27/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan: MDate: 10-5-27 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3953

C

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA855 &amp; DWG

FOLIO REV: CDWG REV: SA 10/06/16

DEBURR

20 0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/06/1620 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 59147**

Thursday, May 27, 2010 9:20:29 AM



Page 2

Item ID: D3953-9

Accept



Setup Start

Revision ID:

Stop

Item Name: Gas Spring Washer



Start Date: 5/27/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 6/4/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

MA 10/06/16

Memo

0.00

20

0

130



Packaging

Packaging

Identify as per dwg &amp; Stock Location: 163

0.00

Memo

0.00

10-6-17

2000

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/21

MF 10-6-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 27, 2010 9:20:34 AM

Page 1

Work Order ID: 59147



Parent Item: D3953-9



Parent Item Name: Gas Spring Washer

Start Date: 5/27/2010

Required Date: 6/4/2010

Comments: IPP RevA: New issue DD verified by:EC  
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750		Purchased	No			100	f	98.9100	0.05	1.052632			



Delrin Round Bar 0.75"



Location	Loc Qty	Loc Code
MAT	64	
- 114595	64	
MAT050	34.91	
112418	3.12	
112480	31.79	

321 SA 10/06/16

2A

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



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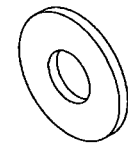
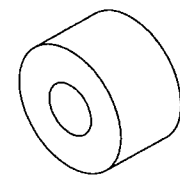
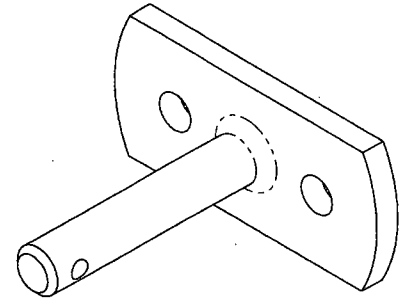
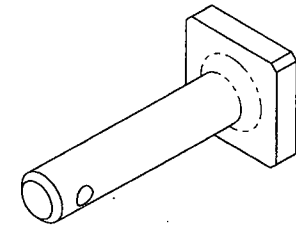
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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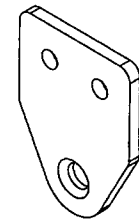
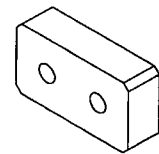
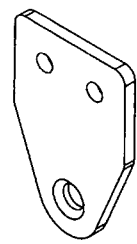
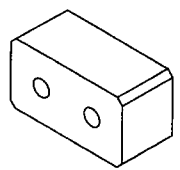
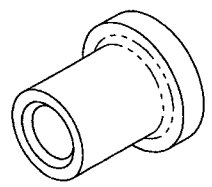
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



**RELEASED**  
R 2010-02-26

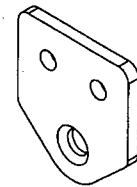
**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59147

RD10527

C	PARTS -19 & -21 ADDED (SHT 1& 4); CSK CALLOUT WAS CHAM (C6-2, B6-3, C6-4); C SYMM WAS C SYM ABOUT (C7-2, C7-4); SECTION C-C REPOSITIONED TO B2-4 REASON: ADDL PARTS REQD; DRAFTING ERRORS	JPH	10.01.29
B	SHEET 3 ZONE C1, DIM 0.05 MIN WAS 0.13, MULTIPLE DIMENSIONS MIN/MAX REMOVED TOLERANCE ADDED REASON: DIFFICULTY INSTALLING COTTER PIN AT NEXT ASSY.	AJS	09.11.11
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<u>QD</u>	DRAWING NO.	REV. C
MFG. APPR.	<u>B</u>	<b>D3953</b>	SHEET 1 OF 4
APPROVED	<u>H</u>	TITLE	SCALE
DE APPR.	<u>H</u>	<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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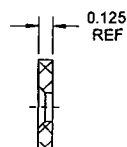
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

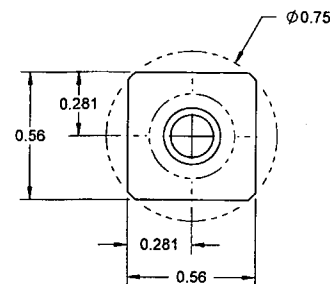
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**NOTE:** Date & initial all entries

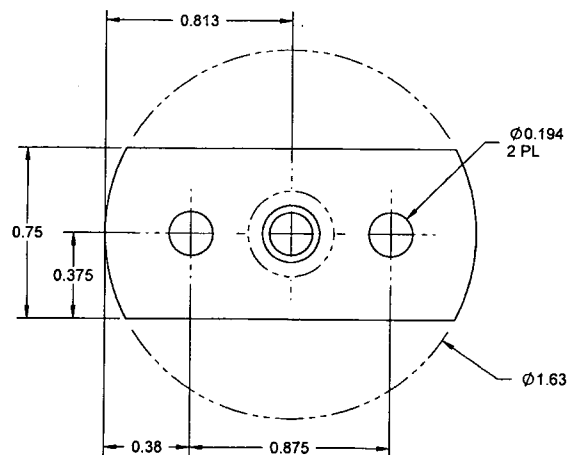
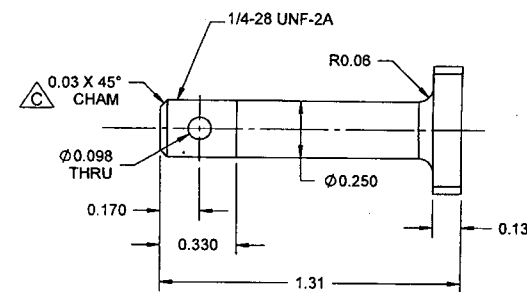
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



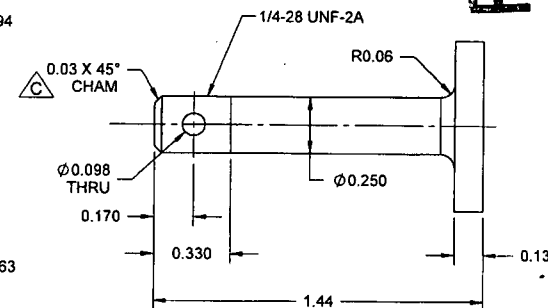
**SECTION A-A<sub>C7-2</sub>**



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



2010-02-26  
RELEASED

- NOTES:
- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 3 & -5: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B  
OR:  
AISI 304/316 STAINLESS STEEL ROD  
REF DART SPEC M304R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.11 lbs  
-3: 0.03 lbs  
-5: 0.06 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3953</b>  TITLE <b>GAS SPRING LID COMPONENTS</b>  COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED TO YOU ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORPUS OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C
DRAWN	JPH		SHEET 2 OF 4
CHECKED	JP		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.01.29		

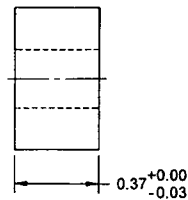
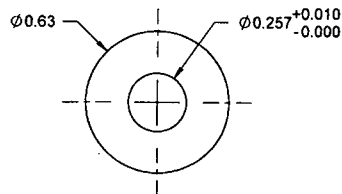
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

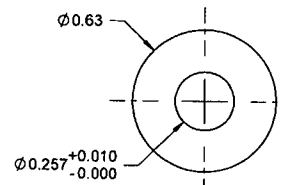
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

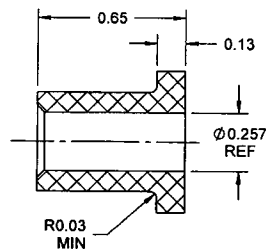
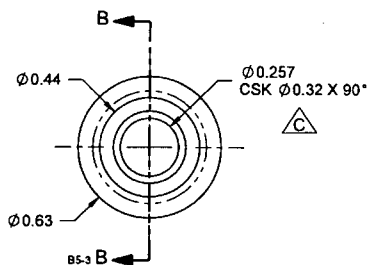
**NOTE:** Date & initial all entries



**D3953-7 GAS SPRING SPACER**

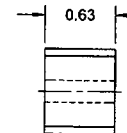
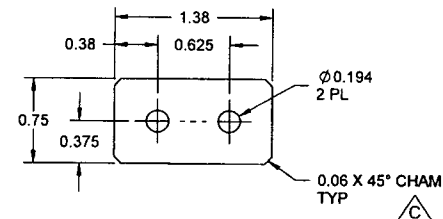


**D3953-9 GAS SPRING WASHER**



**SECTION B-B** 87-3

**D3953-11 GAS SPRING SPACER**



**D3953-13 GAS SPRING SPACER**

**NOTES:**

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

**RELEASED**  
2010-02-26

*w/b 59147*

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3953</b>	REV: C
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 4	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>GAS SPRING LID COMPONENTS</b>	NTS
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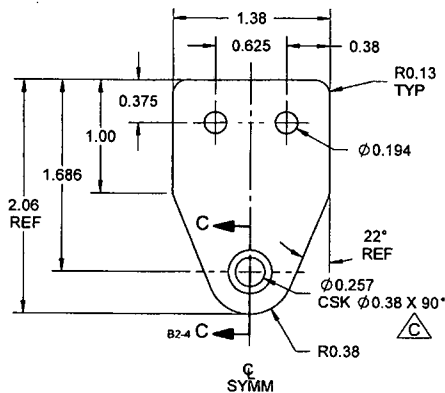
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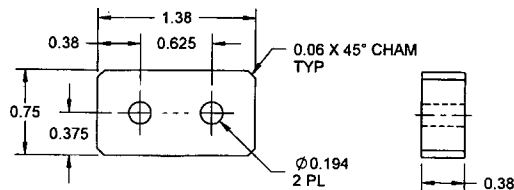
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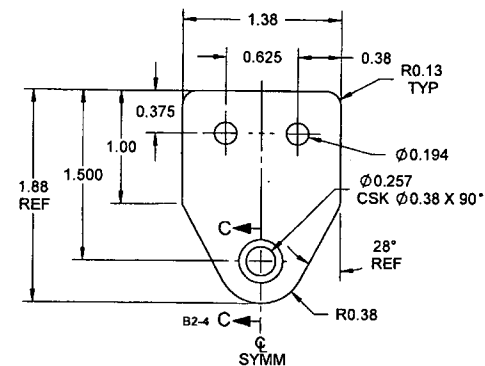
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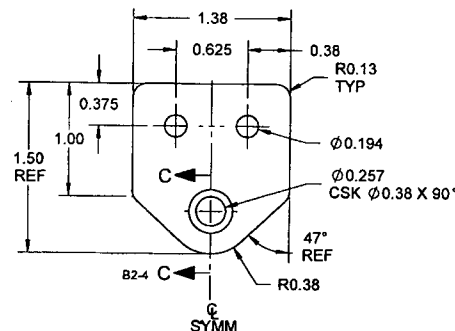
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



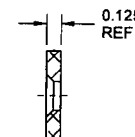
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)



**D3953-19 GAS SPRING BRACKET**  
(SQUARE BASKET)



**D3953-21 GAS SPRING BRACKET**  
(SQUARE BASKET)



**SECTION C-C**

**NOTES:**

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -15: 0.08 lbs

-17: 0.10 lbs

-19: 0.07 lbs

-21: 0.06 lbs

W/U 59147

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	JPH			
CHECKED	<i>[Signature]</i>		DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>		<b>D3953</b>	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>		TITLE	SCALE
DE APPR.	<i>[Signature]</i>		<b>GAS SPRING LID COMPONENTS</b>	NTS
DATE	10.01.29	COPYRIGHT © 2009 BY DART AEROSPACE LTD		
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2010-02-26

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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